

Split

Ship July 15

Work Order ID 60166-1

June 28, 2010 11:51:52 AM



Page 1

Item ID: D4134-041

Revision ID:

Item Name: Wearplate, LH Aft

Start Date: 6/29/10 Start Qty: 3.00

Required Date: 7/15/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

RF

Date: 6/29 Tooling:



Date:

Setup Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4134

A

0.00

100



Waterjet

FLOW CNC Waterjet

304 050

FLOW WATER JET

0.00

POL 6-21

③

110



QC

Quality Control

Memo

0.00

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

S we 66 130

POL 6-21

③

QC8- Inspect parts - second check

0.00

Memo

0.00

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60166

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Item ID: D4134-041

Accept



Setup

Start



Stop

Revision ID:

Item Name: Wearplate, L.H Aft

Start Date: 6/29/10 Start Qty: 2.00



Required Date: 7/15/10 Req'd Qty: 2.00



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

130



Brake NC

Brake NC

Operation
Description

Form as per dwg
NC BRAKE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



QC

Quality Control

Memo QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150



Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: M114705 0.00

Large Fab

Memo

0.00

Weld hard surface using DT NJS as per QSI 004 and Dwg D4134

SJ 15/07/10

D 10-07-13 - one only

10.07.14

①

10.07.15

10

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Order ID 60166

O10 11:54:53 AM



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D4134-041

Accept



Setup Start



Stop



D:

e: Wearplate, LH Aft

e: 6/29/10 Start Qty: 2.00



Date: 7/15/10 Req'd Qty: 2.00



Cust Item ID:

Customer:

:

s: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



ID/
Operation
ID

Description

QC10- Inspect visual per QSI004- ground welds

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp



0.00

8/16/10 15

(X)

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

18 10-07-14 0

Grey Sandtex(Ref4.3.5.6) per QSI005 4.3

M112588

0.00

Memo

0.00

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

12:00 320°
12:30

18 10-7-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60166

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Item ID: D4134-041

Accept



Setup

Start



Revision ID:

Item Name: Wearplate, LH Aft

Stop



Start Date: 6/29/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/07/15

200



Small Fab

Small Fab

Memo

0.00

I- Bond D4134-3 gasket to inner surface of wearplate using a thin layer of 3M
1300/1300L scotch grip adhesive
Batch: M1113174

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Work Order ID 60166

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Item ID: D4134-041

Accept



Setup

Start



Revision ID:

Item Name: Wearplate, LH Aft

Stop



Start Date: 6/29/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

220



Operation
Description

Identify as per dwg & Stock Location:
Packaging

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

6/28/16 O

0.00

Packaging

Packaging

Memo

230



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

J100716

MF
10-7-16

Picklist Print

June 28, 2010 11:51:51 AM

Page 1 / 1

Work Order ID: 60166



Parent Item: D4134-041



Parent Item Name: Wearplate, LH Aft

Start Date: 6/29/10

Required Date: 7/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.25 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4134-3



Manufactured

No

200 Each 0.0000 1 2.000200

B 60660



(1X)

m-h 10/07/15

Gasket

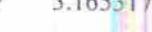
M304S18GA



Purchased

No

100 sf 132.8779 1.5825 3.165317



4.8

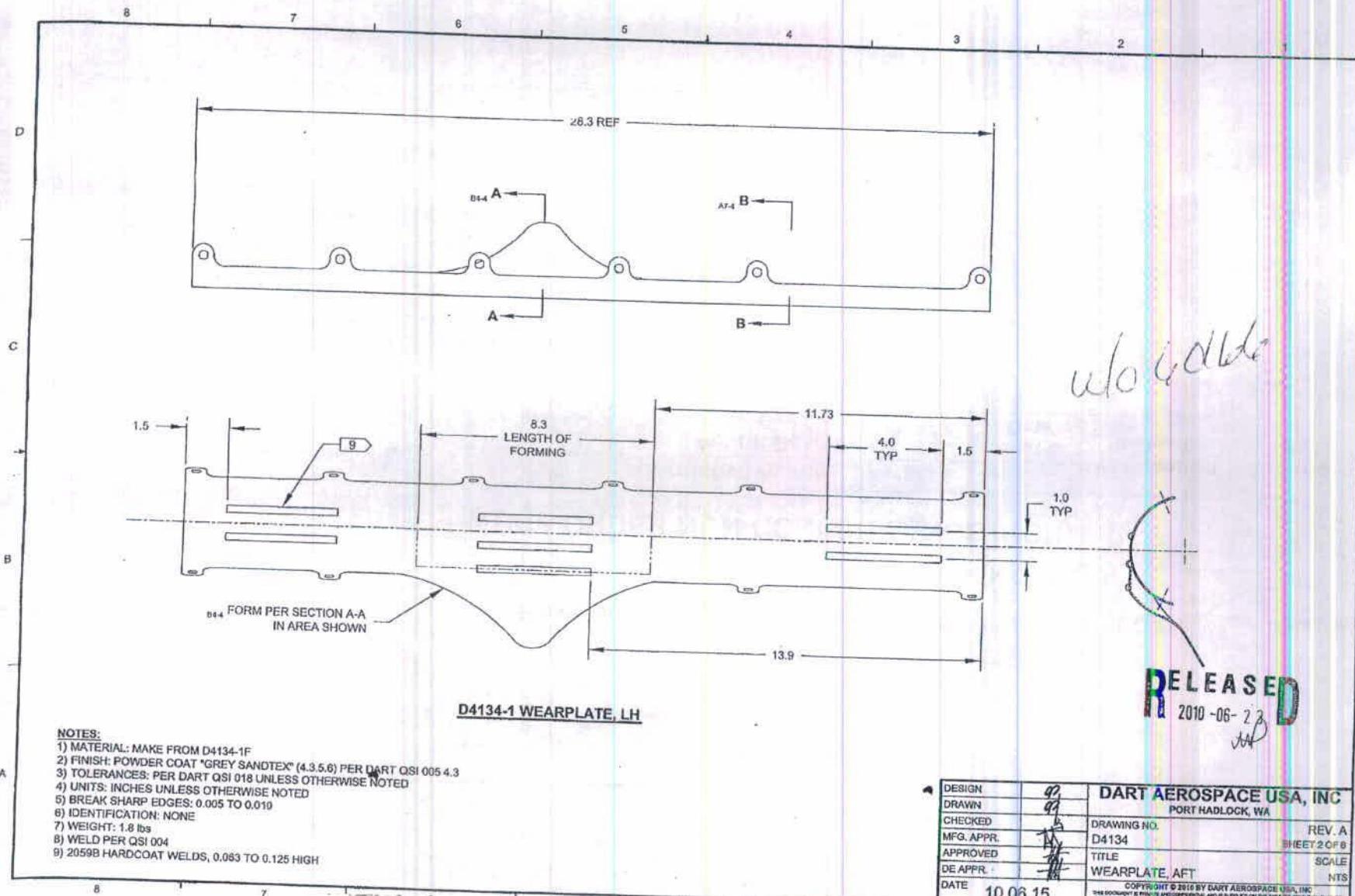
304/316 .050 Sheet

Location	Loc Qty	Loc Code
MAT20	132.8779	
111743	8.86	
112885	28.0179	
113062	96	

B 10-6-24

(3)

113062



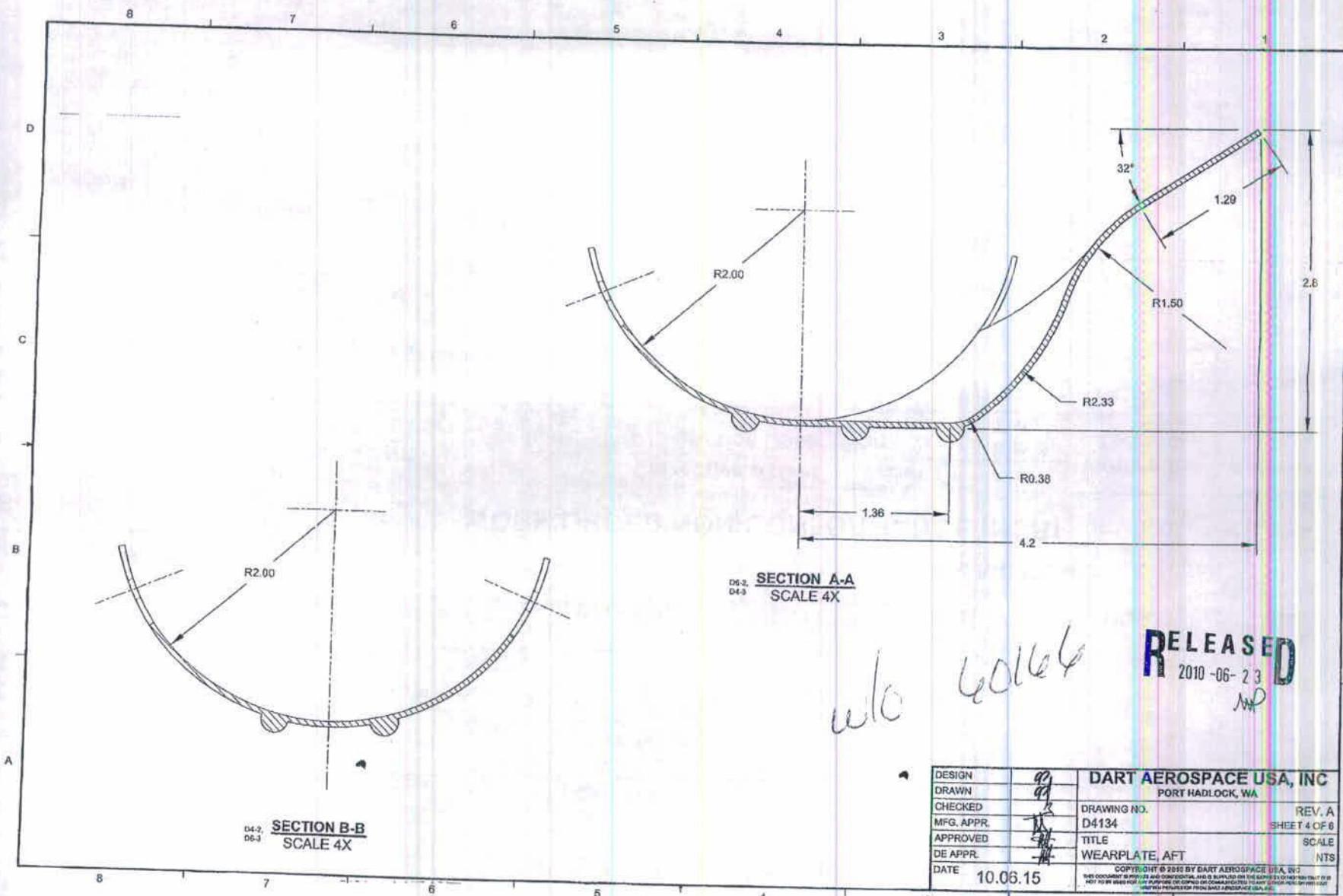
W/O:		WORK ORDER CHANGES							
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
2010-06-23
MP

wlc 40164

DESIGN	99	DART AEROSPACE USA, INC
DRAWN	99	PORT HADLOCK, WA
CHECKED	12	REV. A
MFG. APPR.	11	SHEET 4 OF 6
APPROVED	11	TITLE
DE APPR.	11	WEARPLATE, AFT
DATE	10.06.15	NTS

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consent of Dart Aerospace USA, Inc.

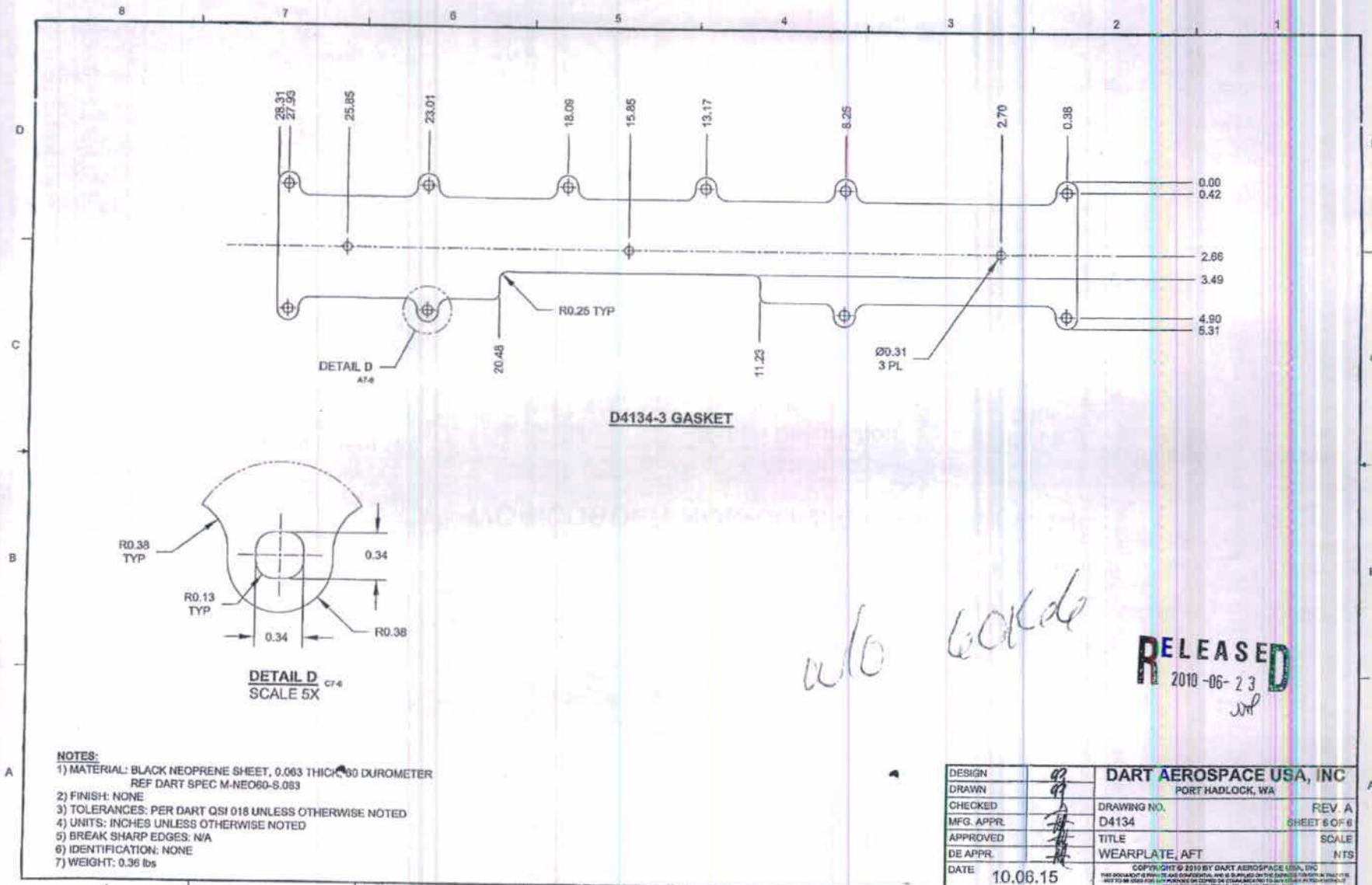
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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES							
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	C0166
Description: WEAR PLATE LH AFT	Part Number:	D4134-041
Inspection Dwg: D4134-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.300	+/- .010	.303		"		
.300	+/- .010	.303		"		
.415	+/- .010	.412				
.87	+/- .030	.816				
2.74	+/- .030	2.75				
4.65	+/- .030	4.640				
5.055	+/- .010	5.053				
5.47	+/- .030	5.468				
6.03	+/- .005 - .001	.705				
.315	+/- .005	.314				
5.84	+/- .030	5.85				
8.34	+/- .010	8.350				
13.170	+/- .010	13.170				
15.65	+/- .030	15.85				
18.092	+/- .010	18.092				
23.03	+/- .010	23.013				
25.25	+/- .030	25.85				
27.94	+/- .010	27.934				
28.31	+/- .030	28.310				
8.05	+/- .020	8.048				
15.73	+/- .030	15.73				
15.98	+/- .030	15.98				
.050	+/- .010	.050				

Measured by:	B
Date:	10-6-09

Audited by:	S
Date:	10/04/09

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/07/13	130	Had to open Rate at .316 to match the jigs	SJ	10/07/13	③	14 10.07.13 09/07/13	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries